



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4294-1

Job Sheet 180372



Part No: D4294-1

Job Qty: 2 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No: re-powder coat gloss black

Due Date: 7/10/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-25 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	7/10/18	7/10/18	0.00	0.00	Start Up Machining-2		BEB 18-07-06
140	HandFinish	2 pcs	7/10/18	7/10/18	0.00	0.12	HandFinish1	~scuff	SA 18-07-06
145	Powdercoat	2 pcs	7/10/18	7/10/18	0.00	0.14	Powdercoat1	re-powder coat FBK 18-7-11 gloss black JB	
150	QC	2 pcs	7/10/18	7/10/18	0.00	0.00	QC3		
151	Small Fab	2 pcs	7/10/18	7/10/18	0.00	0.09	Small Fab-6	10/1A	
152	QC	2 pcs	7/10/18	7/10/18	0.00	0.00	QC5		
180	Packaging	2 pcs	7/10/18	7/10/18	0.00	0.00	Packaging3-2	st533	DA JUL 12 2018
190	QC21-SA	2 Ea	7/10/18	7/10/18	0.00	0.00	QC21		F

Part Op 145 - MASK THREADED HOLE

Descriptions: 151 - INSTALL HELICOIL AS PER DWG

1138839 START: 9.25 O.T. 3.00 FINISH: 9.55

9-8 DAS

21

9-89

JUL 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4294-1	Fitting	2 Ea (1 ea)	90-Start up Operation	
MS21209F1-10	Heli Coil	2 Ea (1 ea)	151-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4294-1	2	5	0
151-Small Fab	MS21209F1-10	2	20	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.065Inches $\pm$ 0.010	0.075 0.055		
2	Fitting	0.063Inches $\pm$ 0.010	0.073 0.053	Radius	
3	Fitting	0.305Inches + 0.030 - 0.010	0.335 0.295		
4	Fitting	3.170Inches $\pm$ 0.030	3.200 3.140		

st 533 x4
x1

Plex 7/5/18 11:11 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor Approval Verification			
		QC / QA Coordinator Approval			

FAULT CATEGORY ☐ Effect ☐ ete/Unqualified ☐ plete/Unclear ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence

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 Container No: S089511
 Part: D4294-1
 Job No: 180372
 Serial No/Batch: S089511
 Revision:
 Inspector:
 Exp Date:
 Instructions:
 Date: 07/06/19